

Work Order ID 85773

Friday, June 15, 2012 9:04:03 AM

85773

Page 1

Item ID: E4663-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Panel

Stop ***NS2***

Start Date: 6/15/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/20/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MUFDate: 12-06-15 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

E4662

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

2024 .040'

Dwg Rev: A Prog Rev: JA

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4 0 Jm 12-6-15

4 0 Jm 12-6-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

(4)

AB

12-6-17 (4)

12/6/18 (4)

Dart Aerospace Ltd

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Required Date: 6/20/2012 Req'd Qty: 4.00 ***4***

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

Identify as per dwg & Stock Location: _____

0.00

160

Packaging

Memo

TABUE

0.00

Packaging

12/6/18 (9)

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/6/18

MP 12-06-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, June 15, 2012 9:04:03 AM

Page 1

Work Order ID: 85773

Parent Item: E4663-1

Parent Item Name: Panel

Start Date: 6/15/2012

Required Date: 6/20/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.06.14 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	112.0112	0.23477	0.9885053			

Jm 12-6-15

Location

Loc Qty

Loc Code

MAT022

112.0111626

120196

25.85

120605

53.6627416

121197

32.498421

120605

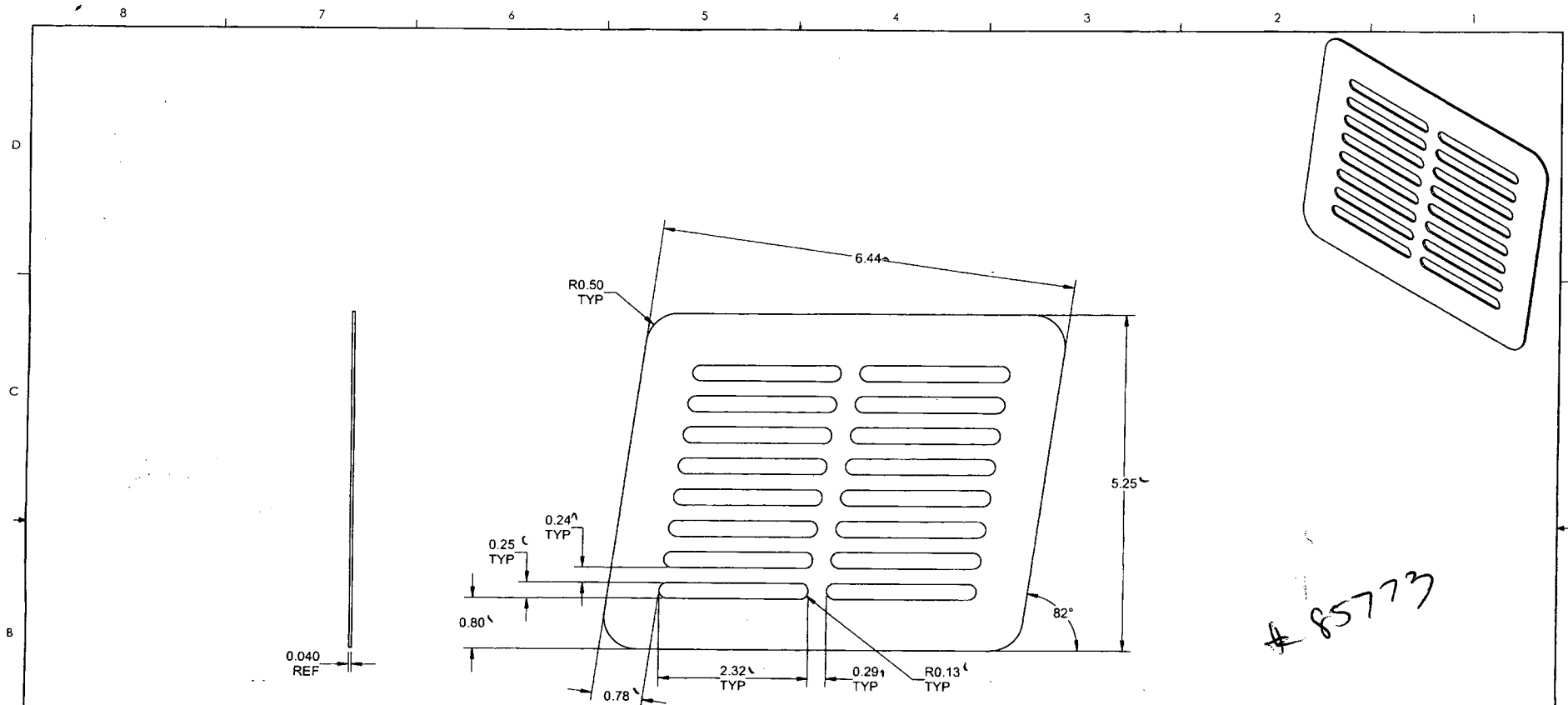
W/O:		WORK ORDER CHANGES					
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E4663-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
OR
6061-T6 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.10 lbs

A		NEW ISSUE		DC		12.06.01	
REV.		DESCRIPTION		BY		DATE	
DESIGN	DC	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA				REV. A	
DRAWN	DC						
CHECKED	DC	DRAWING NO.		E4663		SHEET 1 OF 1	
MFG. APPR.	DC	TITLE		PANEL		SCALE	
APPROVED	N/A					-NTS-	
DE APPR.	N/A						
DATE	12.06.01						

RELEASED
2012-06-13

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